

# Work Order ID 82605

April-03-12 11:29:10 AM

**\*82605\***

Page 1

Item ID: D2324

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Strut

Start Date: 03/04/2012 Start Qty: <sup>15</sup>~~10.00~~

**\*10\***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/03 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2324	Rev C								

100 Small Fab 0.00

**\*100\***

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2324.

15  $\phi$

FF 12-04-20

110 QC5- Inspect part completeness to step on W/O 0.00

**\*110\***

QC

Memo

0.00

Quality Control

8.26.20

(45)

120 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

**\*120\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: OVEN TEMPERATURE:

FINISH TIME:

320015

8:15

15X  $\phi$

M-L  
12/24/24

M121134

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82605

April-03-12 11:29:10 AM

**\*82605\***

Page 2

Item ID: D2324

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Strut

Start Date: 03/04/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00

**\*130\***

QC

Memo

0.00

Quality Control

15x 

140

Identify as per dwg & Stock Location: **S751**

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

13x 

150

QC21- Final Inspection - Work Order Release

0.00

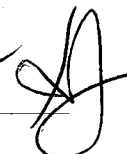
**\*150\***

QC

Memo

0.00

Quality Control

12/4/25 

12-04-25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

April-03-12 11:29:14 AM

Page 1

Work Order ID: 82605

Parent Item: D2324

Parent Item Name: Strut

\*82605\*

\*D2324\*

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: E03.02.28Reformat; Incorporated D2324-3 & D2324-5KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-12A *AN3-12A* Bolt		Purchased	No			100	Each	52.0000	2	20			
				<u>Location</u>				<u>Loc Qty</u>					
				ST351				52					
				114536				1					
				119641				51					
AN960JD10 *AN960.ID10* Washer	NAS1149D0363J	Purchased	No			100	Each	0.0000	4	40			
D2324-3 *D2324-3* Bar		Manufactured	No			100	Each	12.0000	1	10			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				12					
				66193				0					
				76674				12					
D2324-5 *D2324-5* Strap		Manufactured	No			100	Each	30.0000	2	20			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				30					
				76675				30					

\*\*

Loc Code

\*\*

\*\*

Loc Code

\*\*

Loc Code

FF  
12-04-20

FF  
12-04-20

FF  
12-04-20

FF  
12-04-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 82605

**\*82605\***

Parent Item: D2324

**\*D2324\***

Parent Item Name: Strut

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

100

Each

2,449.000

2

20

**\*MS21042L3\***

**\*\***

15

FF 12-04-20

Nut

Location

Loc Qty

Loc Code

ST300

2449

117441

16

117885

32

118451

5

118927

3

119017

2167

119075

166

121162

60

30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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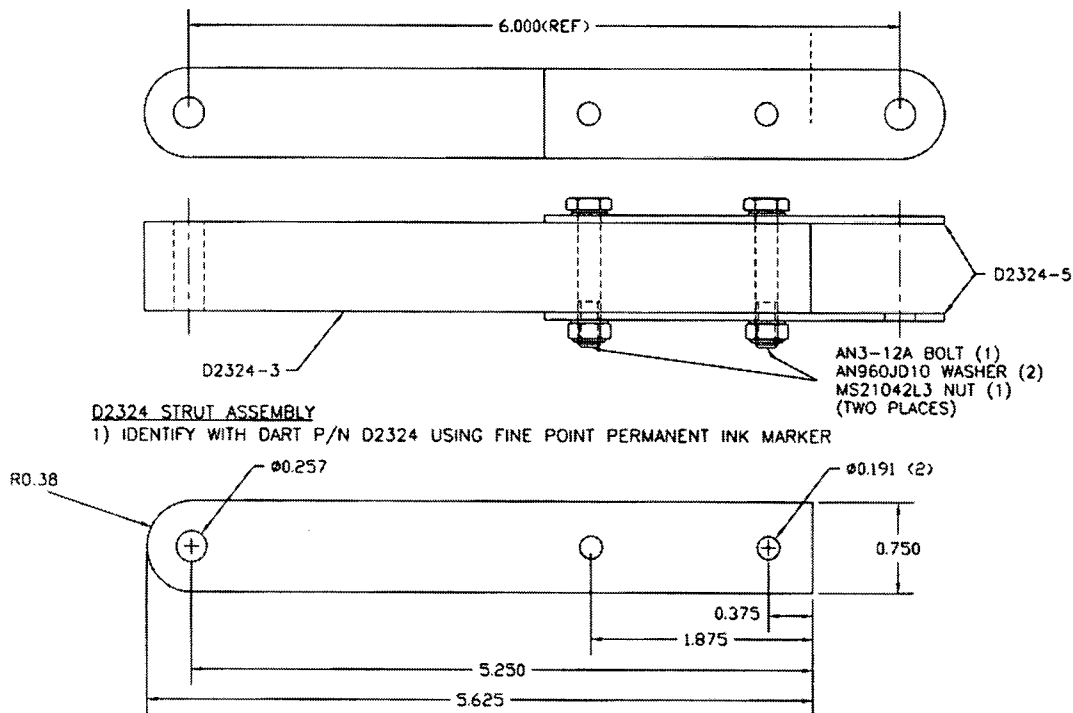
**NOTE:** Date & initial all entries



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D2324	SHEET 1 OF 1
DATE	TITLE		
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

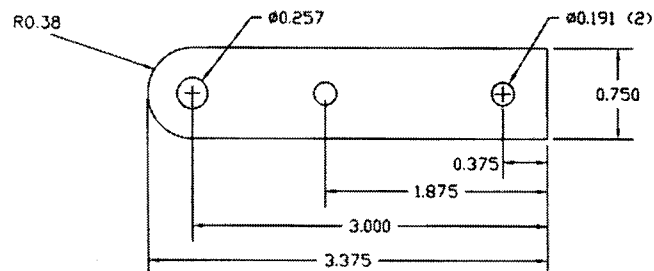
RELEASED

04.12.16 *[Signature]***D2324 STRUT ASSEMBLY**

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

**D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T680.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 02605 MCT  
12/04/03